Qty:

Each

: OUTSIDE WASHER

: D32333

: 9/10/2007

: N/A

: D3233 REV B

Tuesday, 8/21/2007 3:42:58 PM

User:

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

: 34176

Job Number **Estimate Number**

: 11153

P.O. Number

This Issue

Prsht Rev.

First Issue

Written By

Comment

Previous Run

: N)A

: 8/21/2007

Type

B 05.03.31

: MACHINED PARTS

Added Powder CoatKJ/JLM

Additional Product

Checked & Approved By

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M1020TR2000W500

1020-1025 Round Tube

Comment: Qty.:

-97-975 NST/Unit

__Total: 7.8750 f(s)

1020-1025 Round Tube

Material: AISI 1020-1025 Seamless Tubing 2" x 0.500" wall

(M1020TR2.000W.500) Identify for D3233-3

Batch: 1/02210

2.0

HARDINGE



Comment: HARDINGE CNC LATHE SMALL

Turn as per Folio FA518 and Dwg D3233

Deburr

.075" Jus

QC2 3.0

Comment: INSPECT PARTS AS THEY COME OFF MACHINE



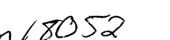
4.0 QC8

Comment: SECOND CHECK

POWDER COATING

5.0

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: 07/09/0/
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	A	Annessal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
						, , , , , , , , , , , , , , , , , , ,				
	1					1				

NOTE: Date & initial all entries

Tuesday, 8/21/2007 3:42:58 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: OUTSIDE WASHER Customer: CU-DAR001 Dart Helicopters Services Part Number: D32333 Job Number: 34176 Job Number: Description: Seq. #: Machine Or Operation: INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock CAN (Location: FINAL INSPECTION/W/O REA 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE U 8749.21 Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER	R CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A :	Date: _			
			QA:	N/C Close	d:	Date:			

NCR:		NCR: WORK ORDER NON-CONFORMANCE (NCI						
		Description of NC		Corrective Action Section B		Verification	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
						- - -		
		·						

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34176
Description: Outside Washer	Part Number:	D3233-3
Inspection Dwg: D3233 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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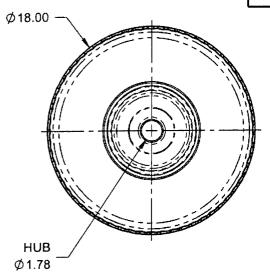
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.620	+0.000/-0.020	0.6155				
0.265	+0.005/-0.000	0,6155	/			
Ø1.378	+/-0.010	1,377				
Ø1.190	+/-0.005	1.190				
Ø2.00	+/-0.030	1.989				
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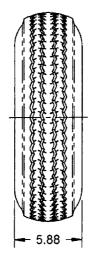
Measured by:	Audited by:	.J.L	Prototype Approval:	N/A
Date: 07/09/15	Date:	04/09/15	Date:	N/A

1	Rev	Date	Change	Revised by _∧	Approve	∌⁄d
ı	A	05.04.26	New Issue	KJ/JLM		
L					7.7	



	1				
DESIGN	13	DRAW	187	DART AEROSPAC HAWKESBURY, ONTARIO, O	
CHECK	ED	APPR	ÆD	DRAWING NO.	REV. B
7	+	war	>	D3233	SHEET 1 OF 3
DATE				TITLE	SCALE
	05.0	3.08		WHEEL ASSEMBLY	1:1
Α	05	5.02.18		NEW ISSUE	
В	05	3.03.08		ADDED BEARING SEALS	
	CHECK DATE	05.0 A 05	DATE 05.03.08 A 05.02.18	DATE 05.03.08 A 05.02.18	CHECKED APPROVED DRAWING NO. D3233 DATE 05.03.08 A 05.02.18 HAWKESBURY, ONTARIO, 1 DRAWING NO. D3233 TITLE WHEEL ASSEMBLY NEW ISSUE

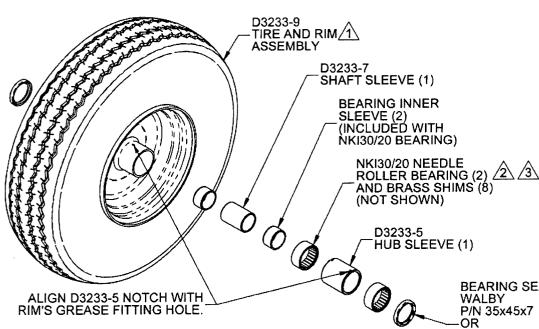






WHEEL SPECIFICATIONS							
SIZE	MAXIMUM LOAD	MAXIMUM INFLATATION LOAD					
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*					

* MANUFATURER'S RECOMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.



D3233-041 WHEEL ASSEMBLY

BEARING SEAL WALBY P/N 35x45x7 OR

CR 35x45x7 HMS4 R P/N 13927

(2 PLACES) SHOP COPY RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
2) POSSIBLE SUPPLIER: GENERAL BEARING
3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT. WITHOUT NOTICE
4) POSSIBLE SUPPLIER: GENERAL BEARING
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

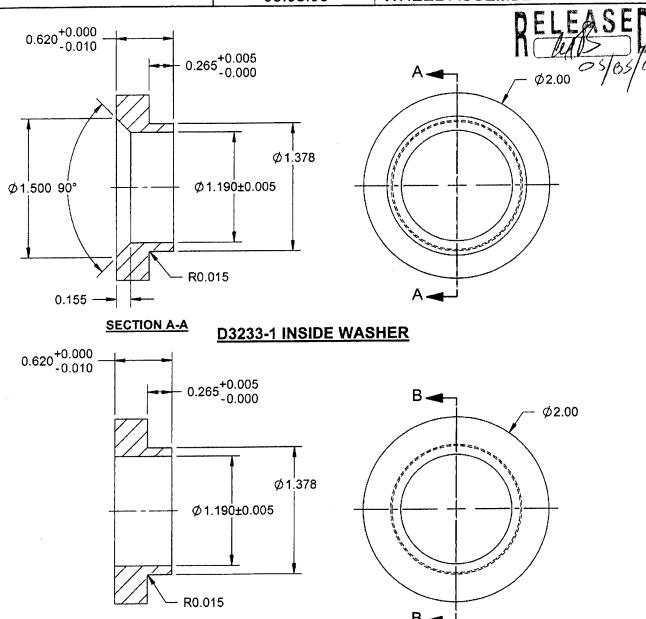
NOTES:

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1			
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	AMPROVED	DRAWING NO.	REV. B
	UCID	D3233	SHEET 2 OF 3
DATE		TITLE	SCALE
05.03.08		WHEEL ASSEMBLY	1:1



D3233-3 OUTSIDE WASHER

SHOP COPY RETURN TO ENGINEERING

SECTION B-B

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM ASMS-00/TROLLED COPY MT1020 SRA OR AMS 5075 OR AMS 5077 COLD DRAWS 5077 COLD D MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESTO AMENDMENT (REF. DART SPEC. M1020TR)

 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3

 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 WORK ORDER

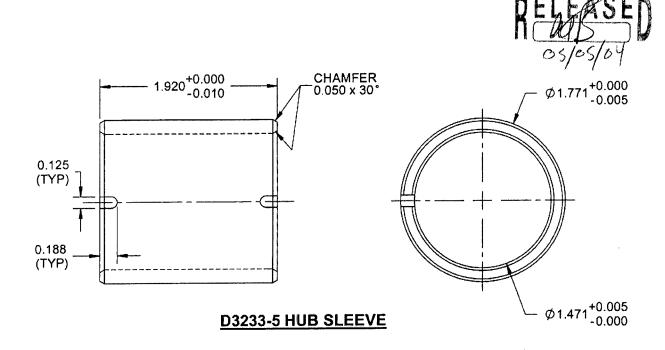
 4) ALL DIMENSIONS ARE IN INCHES WORK ORDER
- 4) ALL DIMENSIONS ARE IN INCHES

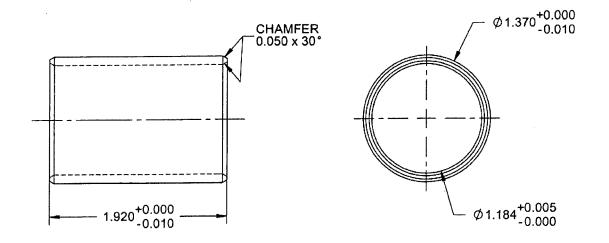
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05	.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1





D3233-7 SHAFT SLEEVE

NOTES:

SHOP COPY

RETURN TO

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 ENGINEERING
 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESSTROLLED COPY
 (REF. DART SPEC. M1020TR)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

 RETORT S

 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

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